

Work Order ID 62361

Tuesday, September 28, 2010 11:30:45 AM

Page 1

Item ID: D3256-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel

Start Date: 9/28/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/5/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *H*Date: *10-9-25* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3256

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3256

Dwg Rev: *E*Prog Rev: *C*

2-Deburr if necessary

*304.032**B10-9-30**(6)*

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-9-30

120

0.00



QC

QC8- Inspect parts - second check

Memo *JM-03*

0.00

Quality Control

*-A1272**6**1009-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 10/5/2010 Req'd Qty: 4.00

Reference:

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Form using D3256-1T2	0.00 0.00	SB 10/11/03				(6)		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8.10/11/04				(+6)		
150  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00	10/11/11 - 4 SP (60)						

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Page 3

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 9/28/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/5/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/05

MF

10-11-4

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Picklist Print

Tuesday, September 28, 2010 11:30:49 AM

Page 1

Work Order ID: 62361



Parent Item: D3256-1



Parent Item Name: Panel



Start Date: 9/28/2010

Required Date: 10/5/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 		Purchased	No			100	sf	97.0896	0.987	4.155789		6.	
304/316 .032 Sheet												HB 10-9-30	

Location

Loc Qty

Loc Code

MAT20

97.0896

109023

30.2896

109057

66.8

109057

6

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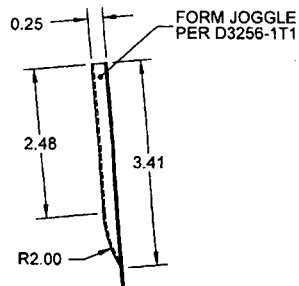
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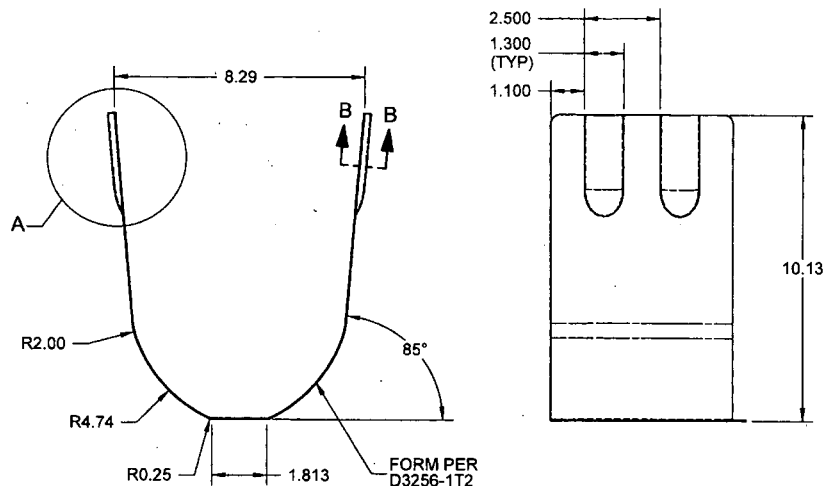
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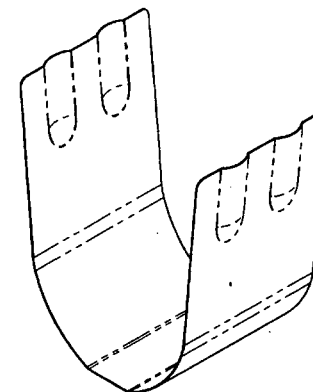
NOTE: Date & initial all entries



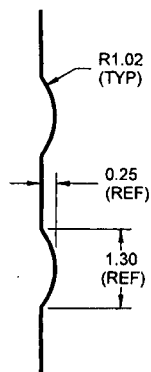
DETAIL A
SCALE 1:2



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1T2)

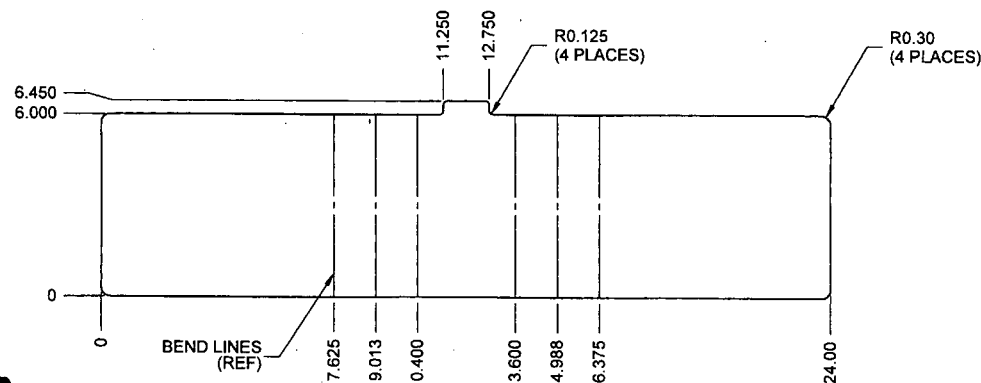


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42304*
D/109-28



SECTION B-B
SCALE 1:2
(VIEW ROTATED)

RELEASED
17 07.10.23



D3256-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.37 lbs

C	D3256-041 ELIMINATED; REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>TH</i>		
DRAWN	<i>A</i>		
CHECKED	<i>CH</i>		
MFG. APPR.	<i>DS</i>		
APPROVED	<i>AP</i>		
DE APPR.			
DATE	07.09.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. C
SHEET 1 OF 2
TITLE **ACCESS PANEL** SCALE 1:4

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